

Date: Wednesday, 5/31/2006 7:36:30 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 27289		
Estimate Number	: 11376		
P.O. Number	: N/A	Part Number	: D33872
This Issue	: 5/31/2006 S.O. No. : N/A	Drawing Number	: D3387 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 27143	Material	: N/A
Written By	: <u>See 1A COMMENT Below</u>	Due Date	: 6/15/2006
Checked & Approved By	: <u>06.05.31</u>	Qty:	6 Um: Each
Comment	: Est:A 05.06.10 New Issue KJ/JLM Est:B 06.03.22 Split c'sink op. EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5680 f(s)/Unit Total : 9.4078 f(s)  
6061-T6 Bar .50" x 6.0"  
Material: 6061-T6/T651 (QQ-A-200/8)  
(M6061T6B0.500x06.000)  
Identify for D3387-2  
Batch: M101092 / 4 pcs

M100817 / 1 pcs  
M180311 / 1 pcs J.F. 06/06/06 (6)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
Cut blank: 6.000" x 0.500" x 17.800" long

J.F. 06/06/06 (6)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Machine as per Folio FA512 and Dwg D3387  
Identify as D3387-2  
Tumble and Deburr NO sharp edges

rmf 06/06/06 6

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
C'sink Ø0.375" as per Dwg D3387

J.G. 06/06/06 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/08

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/31/2006 7:36:30 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 27289

Part Number: D33872

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 06/06/06*

6

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*SL 06/06/07*

6

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST72*

*AL 06/06/07*

6

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*SL 06/06/08*

6

Job Completion



*W 06.06.08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	27289
<b>Description:</b> Arm		<b>Part Number:</b>	D3387-2
<b>Inspection Dwg:</b> D3387 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.503	✓			
7.577	+/-0.010	7.570	✓			
R0.030	+/-0.010	R0.030	✓			
Ø0.191	+0.005/-0.000	Ø0.192	✓			
1.700	+/-0.010	1.701	✓			
0.188	+/-0.010	0.195	✓			
11.405	+/-0.010	11.405	✓			
Ø0.507	+0.000/-0.001	Ø0.507	✓			
2.033	+/-0.005	2.031	✓			
R0.300	+/-0.010	R0.300	✓			
1.000	+/-0.005	1.000	✓			
2.000	+/-0.010	2.002	✓			
1.347	+/-0.005	1.347	✓			
0.250	+/-0.010	0.250	✓			
R0.125	+/-0.010	R0.125	✓			
0.125	+/-0.005	0.134	✓			
R0.032	+/-0.010	R0.032	✓			
Ø0.375 x100°	+/-0.010					
0.500	+/-0.010	0.498	✓			
0.300	+/-0.010	0.306	✓			

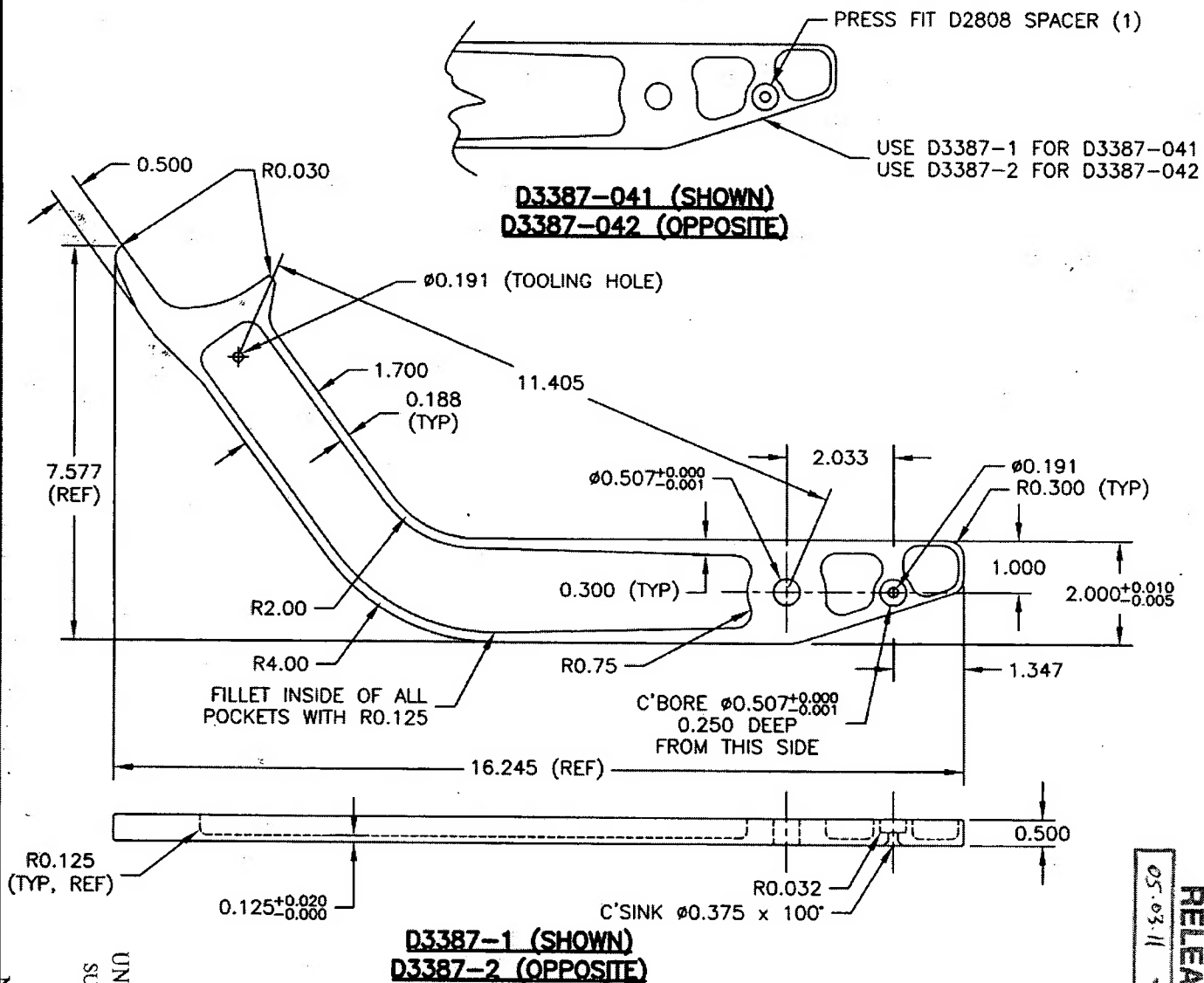
<b>Measured by:</b>	<i>mf</i>	<b>Audited by:</b>	J.F	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/06/06	<b>Date:</b>	06/06/06	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	<i>[Signature]</i>

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DESIGN		DRAWN BY		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. A
				D3387	SHEET 1 OF 1
DATE				TITLE	SCALE
05.01.18				ARM	1:3
A	05.01.18			NEW ISSUE	

05.03.11



1) MACHINE PER DRAWING FILE "D3387-A.DWG"  
2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK  
(REF DART SPEC. M6061T6B0.500)  
3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE

WORK ORDER  
27287  
NO

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